

# Work Order ID 109273

\*109273\*

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November-18-13 8:07:22 AM

Item ID: D044-717-011

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Cold Weather Baffle

Start Date: 11/18/13 Start Qty: 2.00 \*2\*

Cust Item ID:

Required Date: 11/19/13 Req'd Qty: 2.00 \*2\*

Customer:

Reference:

Approvals: Process Plan: W Date: Tooling: Date:

Run Start \*NR1\*

QC: Date: SPC (Y/N): Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
N/A	Rev N/A								
100		0.00							
*100*	DOCUMENT CONTROL		DAS						
DC	Memo	0.00	6						
Document Control	Photocopy bluefile and create labels per PPP D044-717-011CHG001		9-89						
				13/11/18	2				BP
110	Pick Kit	0.00							
*110*									
Packaging	Memo	0.00							
Packaging									
						2x			DAS 31 26 9-89
									13-11-18
120	QC4- 100% Inspect kits for completeness	0.00							
*120*									
QC	Memo	0.00	DAS						
Quality Control			6						
			9-89						
				13/11/18	2				

**Work Order ID 109273****\*109273\***

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November-18-13 8:07:22 AM

Item ID: D044-717-011

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Cold Weather Baffle

Start Date: 11/18/13 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 11/19/13 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00

**\*130\***

Packaging

Packaging

Memo

f6

0.00

Identify and pack for shipping as per PPP D044-717-011

Location: 041

PPP Rev: \_\_\_\_\_

13/11/19

DAS  
31  
989

140

0.00

**\*140\***

QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

DJ/Rm 13/11/20

mt  
13-11-20

# Picklist Print

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Work Order ID: 109273  
Parent Item: D044-717-011  
Parent Item Name: Cold Weather Baffle

Start Date: 11/18/13 Required Date: 11/19/13  
Start Qty: 2.00 Required Qty: 2.00

Comments: IPP Rev:B Removed Manufacturing 05-12-06 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3276-041 Baffle Assembly LH		Manufactured	No			110	Each	4.0000	1	2			DAS 26 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST182		4							
				79169		4			2x				
D3276-042 Baffle Assembly RH		Manufactured	No			110	Each	8.0000	1	2			DAS 26 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST182		8							
				75134		2							
				76168		2							
				79183		4			2x				
D3383-1 Placard		Manufactured	No			110	Each	25.0000	1	2			DAS 26 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST040		25							
				59381		2							
				75135		8			2x				
				76967		15							
AN526C1032R7 Screw		Purchased	No			110	Each	110.0000	8	16		13-11-18	DAS 26 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST346		110							
				123831		10			10x				
				M126175		100			6x				

# Picklist Print

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Work Order ID: 109273

Parent Item: D044-717-011

Parent Item Name: Cold Weather Baffle

Start Date: 11/18/13

Required Date: 11/19/13

Start Qty: 2.00

Required Qty: 2.00

MS20426AD3-4  
RIVET

Purchased

No

110

Each

10,527.000

16

32

DAS  
26  
9-89

## Location

## Loc Qty

## Loc Code

ST334

5042

123164

35

m127432

5007

ST505

24

104374

12

123021

12

ST509

5461

124586

120

125578

5341

32x

MS21059L3  
Nut Plate

Purchased

No

110

Each

138.0000

8

16

13-11-18

DAS  
26  
9-89

## Location

## Loc Qty

## Loc Code

ST316

127

124291

7

125535

3

m126275

41

m127304

76

ST506

11

124308

11

16x

DAS  
6  
9-89

DAS  
51  
9-89

DAS  
6  
9-89

DAS  
26  
9-89

## 2.0 GENERAL NOTES

### COMPATIBILITY

Compatibility of this installation with the aircraft is the **responsibility of the installer**. Ensure that this installation does not conflict with a previous modification.

### CONTINUING AIRWORTHINESS

These installations should be maintained in accordance with the Instructions for Continued Airworthiness ICA-D044-717. Refer to the Aircraft Maintenance Manual for standard shop practices not referred to in these Installation Instructions.

## 3.0 INSTALLATION PROCEDURE

The Dart D044-717-011 Cold Weather Baffle Kit should be installed as follows:

- 3.1 Temporarily locate the D3276-041 Baffle Assembly on the LH inlet as shown in Figure 1. Transfer drill the 4 holes to the aircraft and enlarge to  $\varnothing 0.203$ " (5.20mm). Ensure minimum edge distance of 0.300" from center of hole to edge of opening.
- 3.2 Drill  $\varnothing 0.098$ " holes for MS20426AD3-4 rivets that will be used to install the MS21059L3 nutplates. C'sink  $\varnothing 0.179$ "x100° (4.55mm x100°).
- 3.3 Deburr all drilled/c'sink holes and touch-up with primer per the Aircraft Maintenance Manual.
- 3.4 Install MS21059L3 nutplates on a/c holes using MS20426AD3-4 rivets. Install the D3276-041 Baffle Assembly using AN526C1032-7 screws. Torque screws 15-25 in-lb (2-3 Nm)
- 3.5 Repeat installation for RH side using D3276-042 Baffle Assembly.
- 3.6 Install D3383-1 Placard in full view of the pilot.

## 4.0 WEIGHT AND BALANCE

The following is the net weight increase associated with the installation.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D044-717-011	0.86 lb	0	0	160 in	138 in-lb
Cold Weather Baffle Kit	0.39 kg	0	0	4.06 m	1.6 m-kG

## 5.0 PARTS LIST

Qty	Part Number	Description
X	D044-717-011	COLD WEATHER BAFFLE KIT
1	D3276-041	BAFFLE ASSEMBLY, LH
1	D3276-042	BAFFLE ASSEMBLY, RH
1	D3383-1	PLACARD
8	AN526C1032-7	SCREW
16	MS20426AD3-4	RIVET
8	MS21059L3	NUTPLATE

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Revision: **B**

Date: 05.01.25

